

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007553**Date Inspected:** 26-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Lin**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG & TOWER components**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Dilip Chakrabarti was present during the times noted above for observations relative to the work being performed.

Bay# 11-Tower Assembly

This QA Inspector randomly observed the following work in progress:

SAW Process:

Welding of weld joint# 5A located on PCMK WD1 A6001-1,2,3. Welder is identified as 042195. ZPMC QC is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-4221-B-U3C-S-1.

Welding of weld joint# 83B located on PCMK WSD1 FCSA4-2A/C. Welder is identified as 040772. ZPMC QC is identified as Li Lin. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2221-B-U3C-S-2.

Welding of weld joint# 42B located on PCMK WSD1 FCSA4-2A/C. Welder is identified as 041716. ZPMC QC is identified as Li Lin. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2221-B-U3C-S-2.

Welding of weld joint# 47 located on PCMK WSD1 FCSA4-2A/C. Welder is identified as 202756. ZPMC QC is identified as Li Lin. The welding variables recorded by QC appeared to comply with the specified WPS no.

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B-T-2321-B-P3-S2.

Welding of weld joint# 73B located on PCMK WSD1 FCSA4-2Z/Z. Welder is identified as 044558. ZPMC QC is identified as Fu Wei Min. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2221-B-U3C-S-2.

Bay# 19-OBG Assembly

This QA Inspector randomly observed the following work in progress:

Ultrasonic Testing (UT):

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6027 UT report on this date. The member and the weld designations are as follows:

Sl # Section # Weld # Green Tag # Location

1. FB 016-042 021 R1 NA NA
2. FB 028-012 148 R1, 127 R1 NA NA
3. FB 020-008 148 R1 NA NA
4. FB 027-012 146 NA NA
5. FB 012-037 043 NA NA
6. FB 012-036 043 NA NA

OBG Trial Assembly Area

This QA Inspector randomly observed the following work in progress:

FCAW Process:

Root pass welding of corner joint located between PP 25 & PP 26 of 4AW and 4BW. Welder is identified as 202841. ZPMC QC is identified as Pan Wen Long. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2231T.

Unless otherwise noted, all work observed on this date appeared to be generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversation

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Chakrabarti,Dilip Kumar	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
